

Order ID 61928-2

September 09, 2010 12:55:16 PM

~~PRELIMINARY ISSUE~~

10.10.09



Page 1

Item ID: D4180-4

Revision ID: PRELIM

Item Name: Gusset

Start Date: 9/9/2010 Start Qty: 2.00

Required Date: 9/16/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date: 10-9-09

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4180

PA1

100



Waterjet

FLOW CNC Waterjet

0.00

Memo

0.00

1-Cut as per Dwg

Dwg Rev: PA1

Prog Rev: PA4

2-Deburr if necessary

HB10-9-13

(4)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

HB10-9-13

Work Order ID 61928

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Page 2

Item ID: D4180-4

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00 - inspected to PA1

0.00

Day, only
S 10/9/13



130



Brake NC

Brake NC

Bend as per dwg

Memo

0.00

0.00

S 10/9/14



140



QC

Quality Control

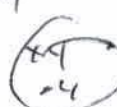
QC5- Inspect part completeness to step on W/O

Memo

0.00 - inspected to PA1

0.00

Day only
S 10/9/14



Work Order ID 61928

Thursday, September 09, 2010 12:55:16 PM

Page 3

Item ID: D4180-4

Accept

Revision ID: PRELIM

Item Name: Gusset

Start Date: 9/9/2010 Start Qty: 2.00

Required Date: 9/16/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hour

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

160

QC3- Inspect Part Finish

QC

Memo

Quality Control

170

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

Packaging

0.00

composites

25 10-10-01 x3

Work Order ID 61928

Thursday, September 09, 2010 12:55:16 PM



Page 4

Item ID: D4180-4

Accept



Setup Start



Revision ID: PRELIM

Item Name: Gusset

Stop



Start Date: 9/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/04

BS 10-10-01
③

POSITIVE RECALL

EFFECTIVE 10.9.09 AUTH LL

RELEASED ↓ DATE 10.10.09

PER ~~RE~~ RELEASED PAGE

DATED 10.09.29

Picklist Print

Thursday, September 09, 2010 12:55:20 PM

Page 1

Work Order ID: 61928

Parent Item: D4180-4

Parent Item Name: Gusset



Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	125.2600	0.114	0.24			
6061-T6 .125 Sheet													



B10-9-13

Location

Loc Qty

Loc Code

MAT21

125.26

113608

96

114352

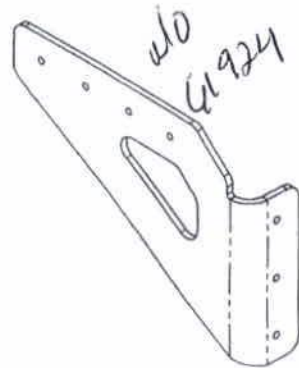
29.26

114352

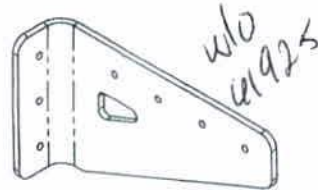
(4)

Koude / Bom / Ax F
 → DOWE

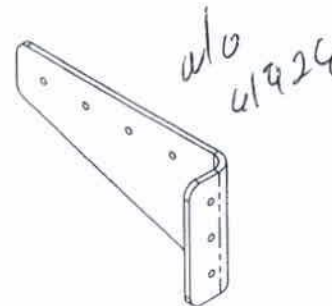
x 2 erde



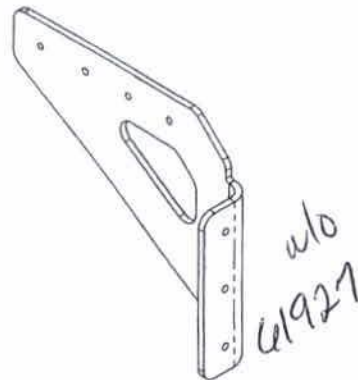
D4180-1 GUSSET



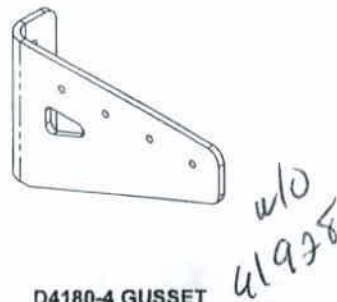
D4180-3 GUSSET



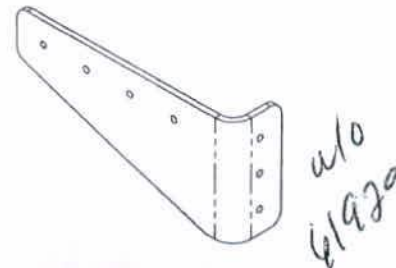
D4180-5 GUSSET



D4180-2 GUSSET



D4180-4 GUSSET



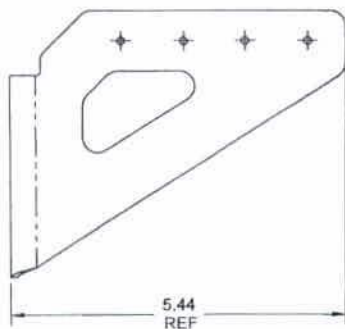
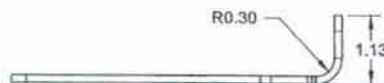
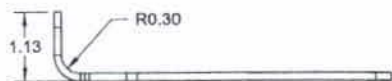
D4180-6 GUSSET

41928
 PL 10-9-09

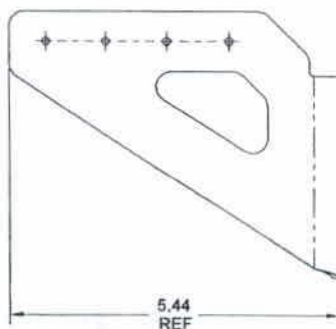
PRELIMINARY ISSUE
 10.09.08

PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.03		

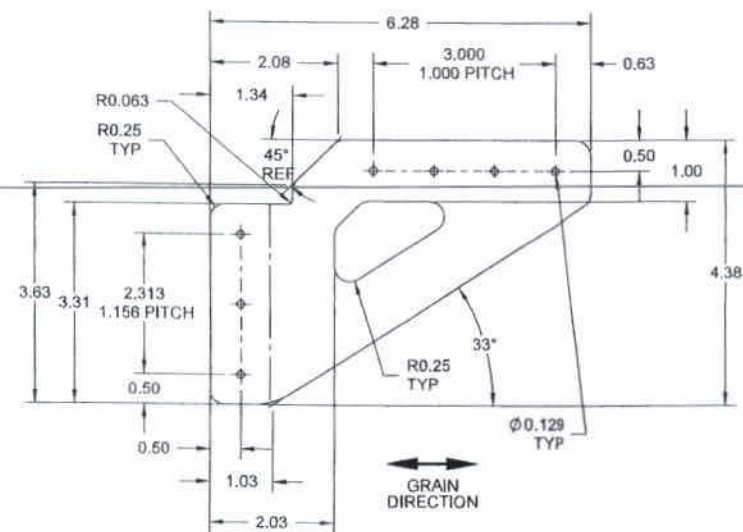
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4180	REV. PA1 SHEET 1 OF 4
TITLE POD FRAME GUSSETS	SCALE NTS
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D4180-2 GUSSET
MAKE FROM D4180-1F



D4180-1 GUSSET
MAKE FROM D4180-1F



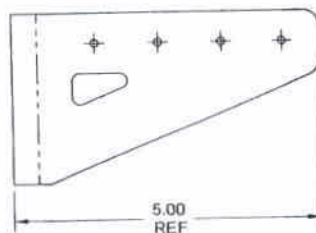
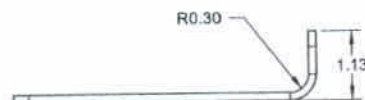
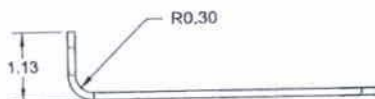
D4180-1F GUSSET FLAT PATTERN

wlc 0928
PRELIMINARY ISSUE
10.09.08

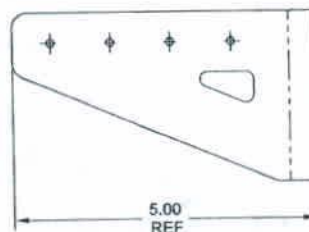
NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF, DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs EACH

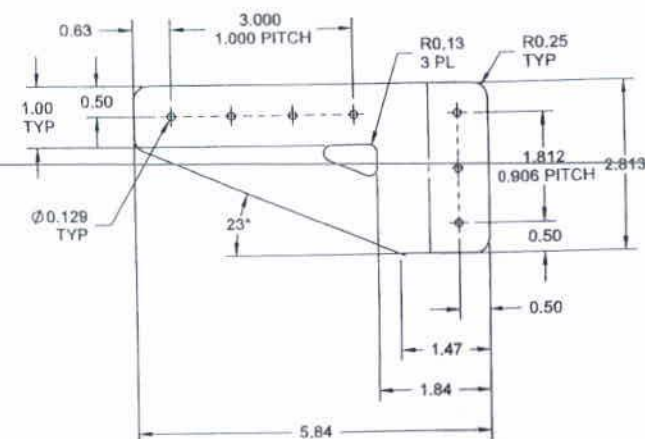
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA
MFG. APPR.		D4180	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		POD FRAME GUSSETS	NTS
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D4180-4 GUSSET
MAKE FROM D4180-3F



D4180-3 GUSSET
MAKE FROM D4180-3F



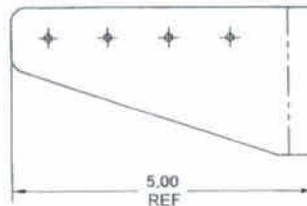
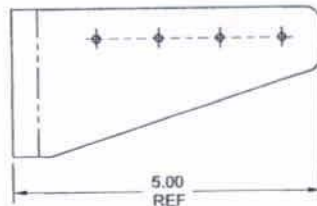
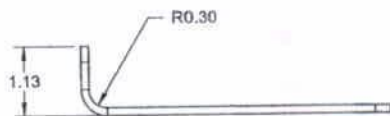
D4180-3F GUSSET FLAT PATTERN

w/o 61928

PRELIMINARY ISSUE
10.09.08

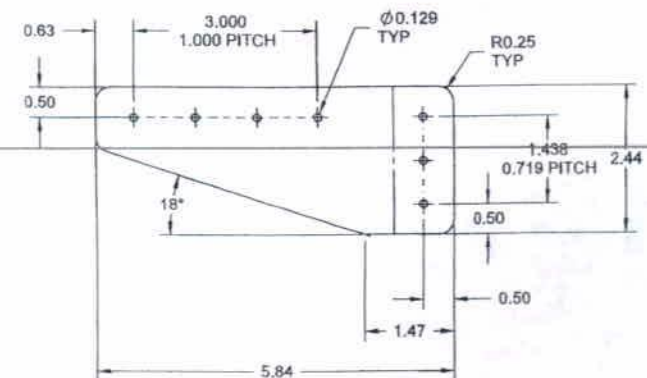
- NOTES:**
- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.15 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4180	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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D4180-5 GUSSET
MAKE FROM D4180-5F

D4180-6 GUSSET
MAKE FROM D4180-5F



D4180-5F GUSSET FLAT PATTERN

W/O 01928

PRELIMINARY ISSUE
10.09.08

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4180	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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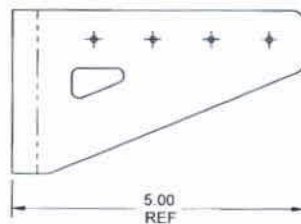
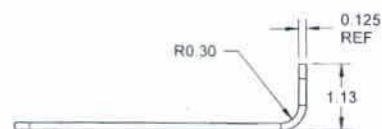
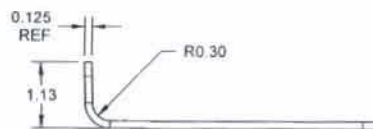
DART AEROSPACE LTD		Work Order: 61928
Description: GUSSET		Part Number: D4130-4
Inspection Dwg: D4130-4 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

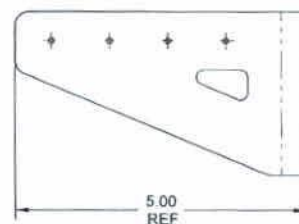
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.139	+0.005 -0.001	.130	X		V	B03
.50	+/- .030	.501	X		V	
.63	+/- .030	.673	X		V	
3.00	+/- .030	3.000	X		V	
1.000	+/- .030	1.000	X		V	
2.813	+/- .010	2.817	X		V	
1.812	+/- .010	1.812	X		V	
.906	+/- .010	.907	X		V	
.50	+/- .030	.503	X		V	
.50	+/- .030	.501	X		V	
1.47	+/- .030	1.472	X		V	
1.84	+/- .030	1.851	X		V	
5.84	+/- .030	5.854	X		V	
1.00	+/- .030	1.000	X		V	
.125	+/- .010	.123	X		V	

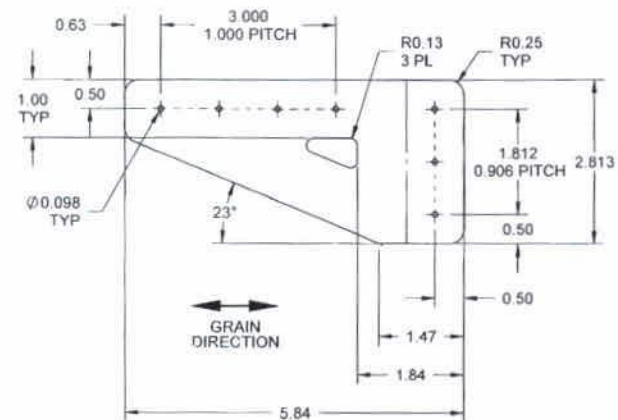
Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-9-13	Date: 10/09/13	Date:	N/A
Inspector: PA1 Day 014		Revised by: KJ/JLM	Approved:
Rev A	Date	Change	
		New Issue	



D4180-4 GUSSET
MAKE FROM D4180-3F



D4180-3 GUSSET
MAKE FROM D4180-3F



D4180-3F GUSSET FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.15 lbs EACH

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4180 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		POD FRAME GUSSETS NTS
DATE	10.09.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD

RELEASED
2010-09-29

61928